

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011633**Date Inspected:** 24-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:** Mr.Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder( OBG)**Summary of Items Observed:**

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

**OBG TRIAL ASSEMBLY**

This QA inspector measured and recorded root gap and offset for below segment along with QA inspector Mr. Manoj Prabhune. Reports forwarded to team leader for further action.

7BE-7CE

This QA Inspector observed the following work in progress:

**SEGMENT- 7BE-7CE**

Flux Cored Arc Welding (FCAW) welding of weld joint OBE7A-008. Welder is identified as 067949. ZPMC Quality Control (QC) is identified as Mr.Shenjian Bo. The welding variables recorded by QC appeared to comply with the Applicable WPS: B-T-223(2)1T-2.

**SEGMENT- 7BE-7CE**

Flux Cored Arc Welding (FCAW) welding of weld joint OBE7A-008. Welder is identified as 220067. ZPMC

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## WELDING INSPECTION REPORT

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Quality Control (QC) is identified as Mr. Shenjian Bo. The welding variables recorded by QC appeared to comply with the Applicable WPS: B-T-223(2)1T-2.

### SEGMENT- 7BE-7CE

Flux Cored Arc Welding (FCAW) welding of weld joint OBE7A-008. Welder is identified as 066471. ZPMC Quality Control (QC) is identified as Mr. Shenjian Bo. The welding variables recorded by QC appeared to comply with the Applicable WPS: B-T-223(2)1T-2.

### SEGMENT-6CE

Shielded Metal Arc Welding (SMAW) welding of Repair weld joint CA030-004. Welder is identified as 048047. ZPMC Quality Control (QC) is identified as Mr. Zhang Qiang. The welding variables recorded by QC appeared to comply with the Applicable WPS: WPS-345-SMAW-2G(2F)-FCM-Repair-1 and Critical Welding Repair Report (CWR) is : B-CWR1139.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

Only general conversation was held between QA and Quality Control (QC) concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 1500042372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Prabhu, Surendra	Quality Assurance Inspector
<b>Reviewed By:</b>	Miller, Mark	QA Reviewer

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